

Work Order ID 164521***164521***

Page 1

Wednesday, July 19, 2017 2:48:22 AM

Item ID: 646.3014 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Blade
Start Date: 7/28/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/11/2017 Req'd Qty: 10.00 ***10*** Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 20 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
646.3000	N/C

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank at 2.670"

0.00

0.53

10

φ

DAS
45
9-89

2017-8-10

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB150

DWG REV: N/CFOLIO REV: 110

1.52

2.84

10x

φ

DAS
45
9-89

2017-8-10

2- deburr and break all sharp edges except otherwise noted

KNIFE EDGE MUST BE SHARPENED USING STONE, REMOVE ALL
BURRS ON CUTTING EDGE

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.20				10x	Ø		DAS 45 9-89 2017-8-10 mm 2017/08/10
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.20							17-8-13
140 *140* Outsource I Outsource process - Heat Treat	Outsource process - Heat Treat Memo HEAT TREAT AS PER DWG, SEE NOTE #3 ISSUE P/O: 37428	0.00 480.00				10			DAS 13 9-89 2017/08/15

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
150									
Packaging	Memo	0.20							
Packaging									
155	QC5- Inspect part completeness to step on W/O	0.00							
155									
QC	Memo	0.20							
Quality Control									
160	Spray Painting per QSI005 4.2	0.00							
160									
SprayPaint	Memo	0.30							
Spray Painting	PRIME AS PER DWG, SEE NOTE #4								
	PRIMER BATCH: <u>137287</u>								

10x8017-8-29

DAS 38 AUG 29 2017

DAS 41 SEP 05 2017

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170	QC14- Inspect Spray Paint	0.00							
170									
QC	Memo	0.20							
Quality Control									
180	Identify as per dwg & Stock Location: <u>CL401</u>	0.00							
180									
Packaging	Memo	0.10							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.10							
Quality Control									



SEP 13 2017

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
2241 8 26								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐					

Picklist Print

Wednesday, July 19, 2017 2:48:25 AM

Page 1

Work Order ID: 164521

164521

Parent Item: 646.3014

646 3014

Parent Item Name: Blade

Start Date: 7/28/2017

Required Date: 8/11/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 12/11/09 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	28.8210	0.223	2.347368			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

Loc Qty

Loc Code

MAT010

28.821

M137285

0.321

M137625

4.5

M138009

24

DAS

45

9-89

2017-7-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

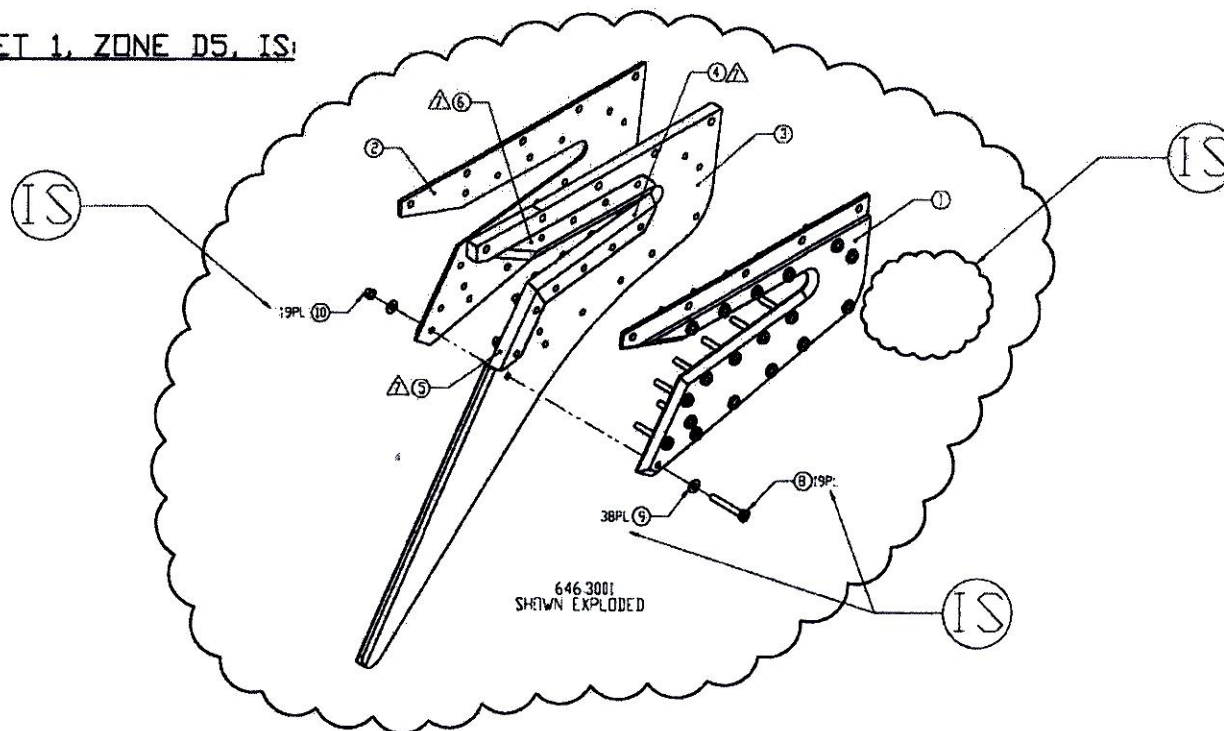
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.		02195		SHEET 1 OF 4	
DWG NO.	646.3000	REV: N/C	PREPARED BY S. HUFF	DATE: 01/05/09	EFFECT ON DWG ☐ INC. ☒ UNINC.
DWG TITLE:		LOWER CUTTER ASSY			
APPROVED BY:	ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF:	NEXT ORDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		REASON: REMOVED RIVETS IN FAVOR OF ADDITIONAL SCREWS			

SHEET 1, ZONE D5, IS:



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 164521 MWS
1/7/20

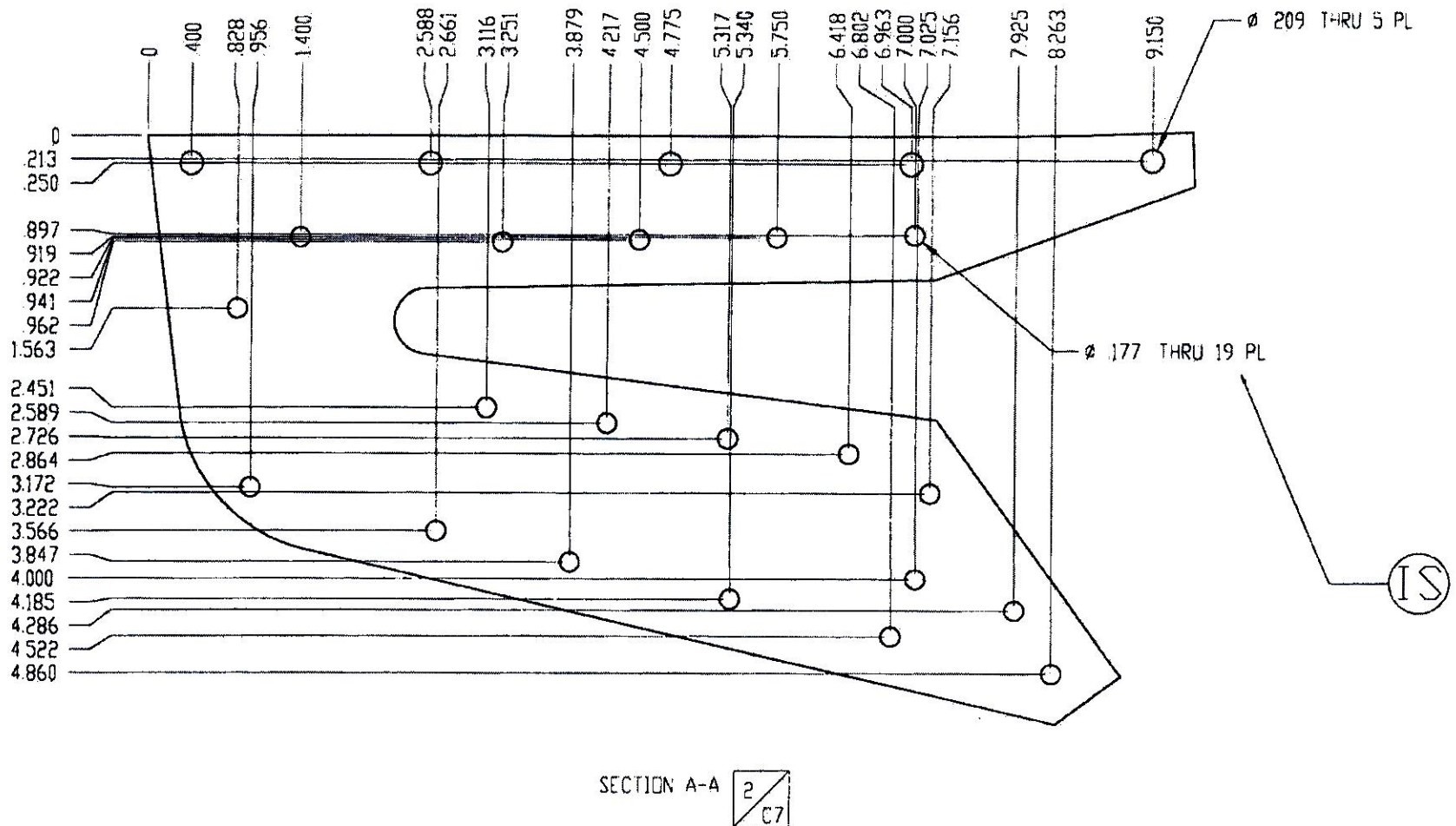
10	R	601.1541	19	LOCKNUT	MS21042L08
9	R	601.2764	38	WASHER	NAS1149FN832P
8	R	601.2765	19	SCREW	MS27039-0819
7	D	601.2766	2	RIVET	MS20470AD5-18
			3001		
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
DOCUMENTS EFFECTED:				CHANGE CATEGORY	
				DER REVIEW REQUIRED	

☐ MDL ☒ INSTALL INSTRUC ☒ ICA ☐ FMS ☒ BOM

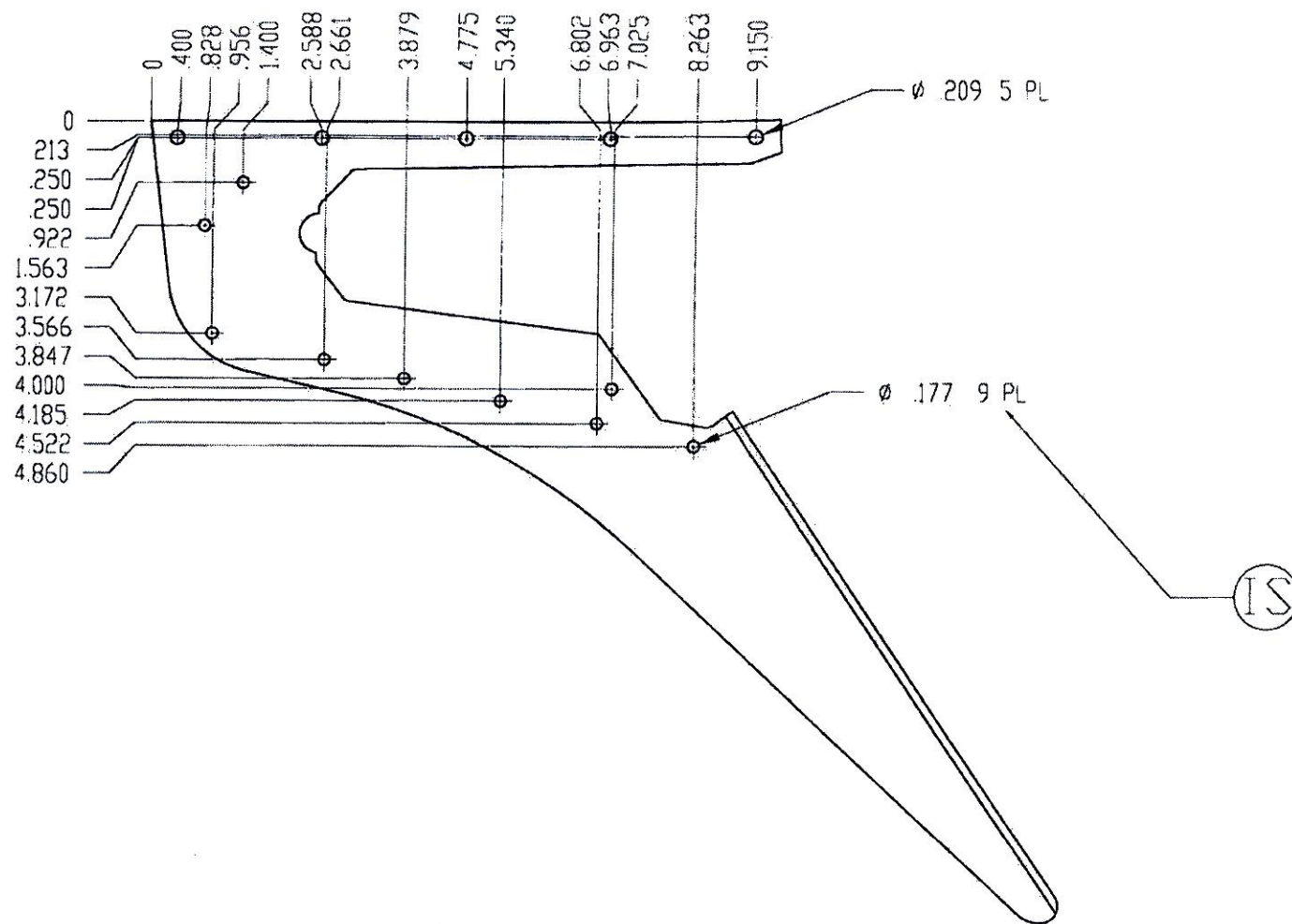
☐ MAJOR ☒ MINOR

☐ YES ☒ NO

SHEET 3 IS:



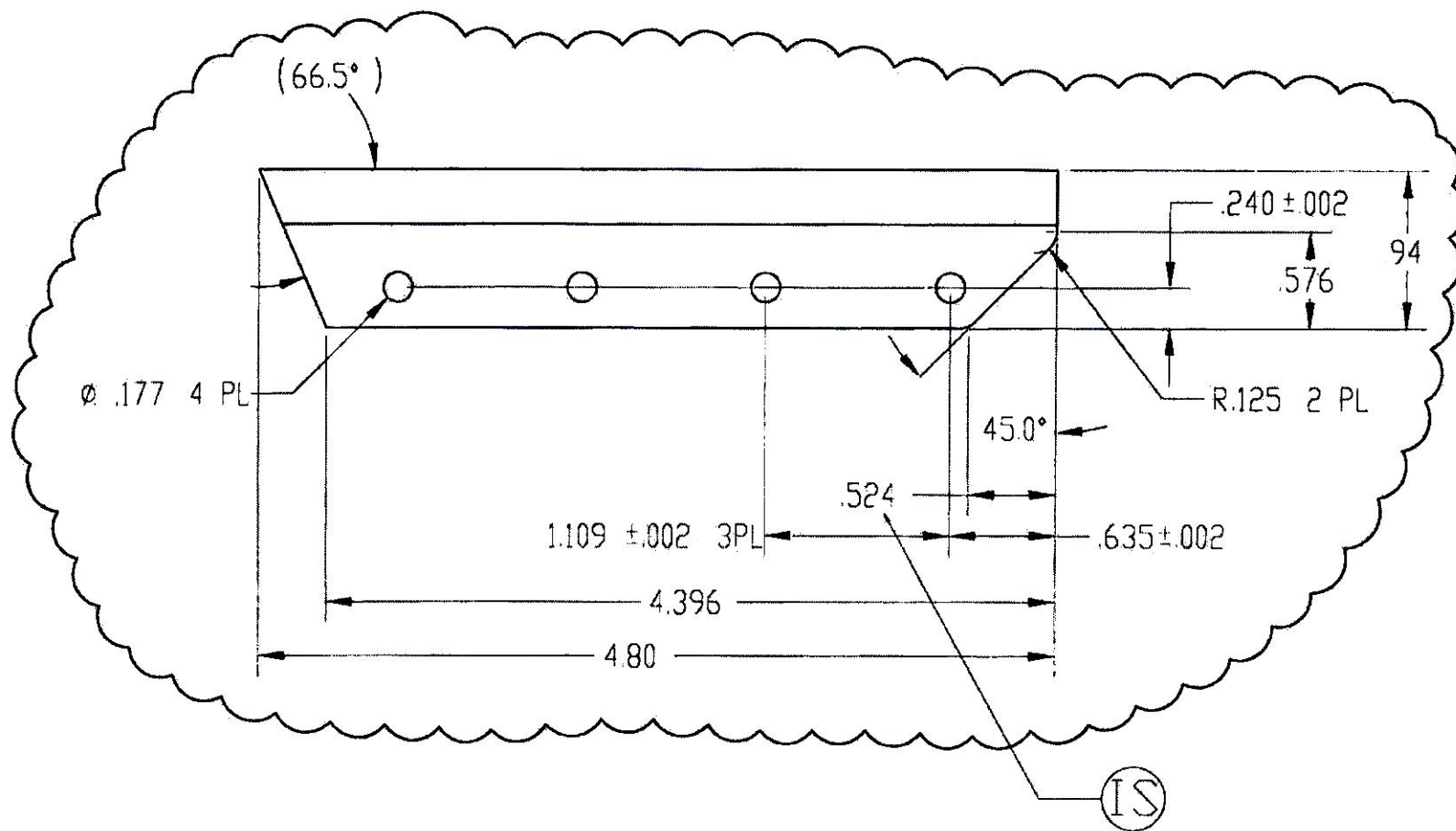
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

SHEET 5 IS:

SECTION F-F

4
B6

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

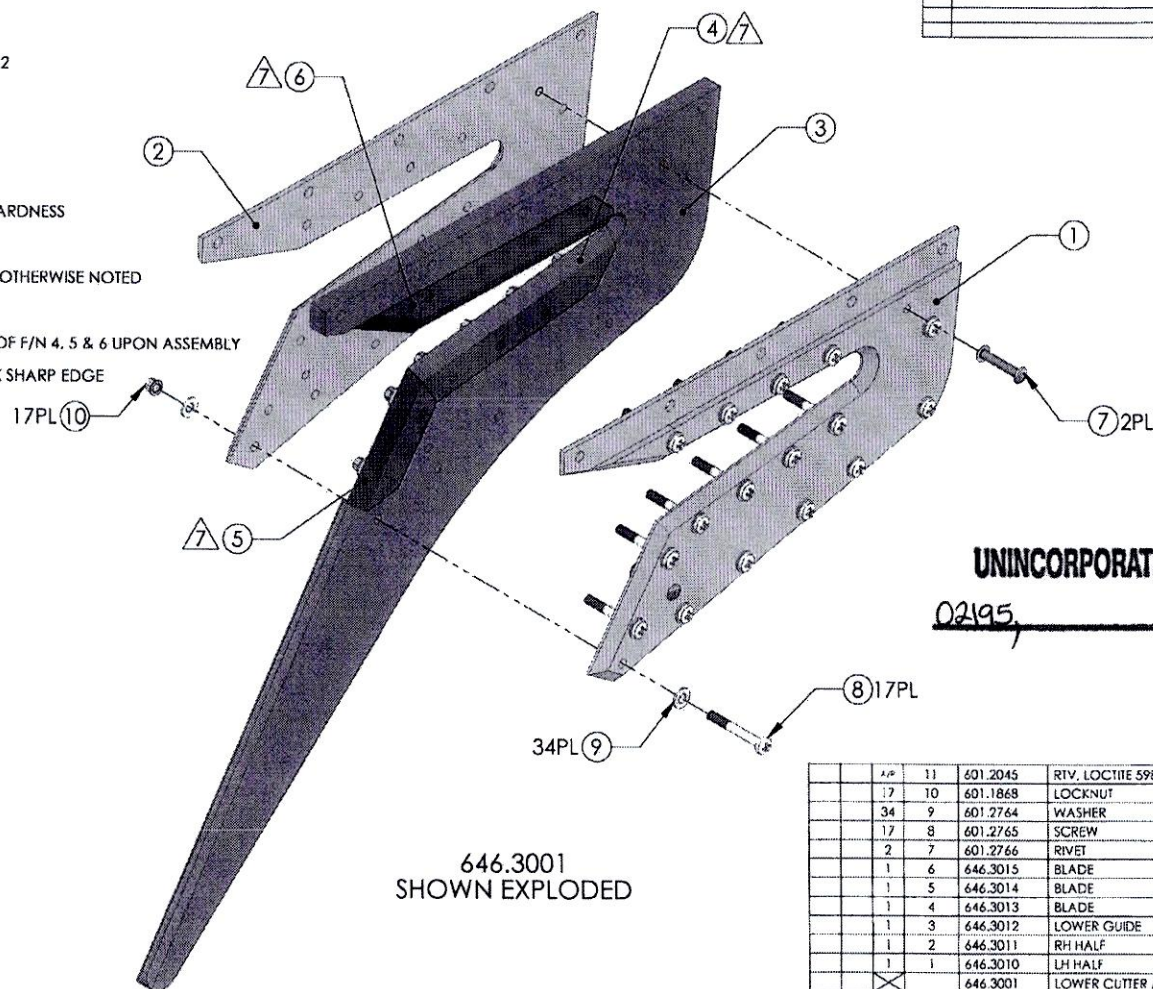
SHEET 6, ZONE C4, IS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2. COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 Rc ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 11 AS REQUIRED TO ALL FAYING SURFACES OF F/N 4, 5 & 6 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE



646.3001
SHOWN EXPLODED

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

UNINCORPORATED ECN(s)

02/95

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
11		601.2045	RTV, LOCTITE 598		
17	10	601.1868	LOCKNUT	MSD7543-04	
34	9	601.2764	WASHER	NASS14891-853P	
17	8	601.2765	SCREW	MSD7079-081R	
2	7	601.2766	RIVET	MSD040704-05-18	
1	6	646.3015	BLADE		
1	5	646.3014	BLADE		
1	4	646.3013	BLADE		
1	3	646.3012	LOWER GUIDE		
1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

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11		601.2045	RTV, LOCTITE 598		
17	10	601.1868	LOCKNUT	MSD7543-04	
34	9	601.2764	WASHER	NASS14891-853P	
17	8	601.2765	SCREW	MSD7079-081R	
2	7	601.2766	RIVET	MSD040704-05-18	
1	6	646.3015	BLADE		
1	5	646.3014	BLADE		
1	4	646.3013	BLADE		
1	3	646.3012	LOWER GUIDE		
1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

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2	7	601.2766	RIVET	MSD040704-05-18	
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1	5	646.3014	BLADE		
1	4	646.3013	BLADE		
1	3	646.3012	LOWER GUIDE		
1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

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17	8	601.2765	SCREW	MSD7079-081R	
2	7	601.2766	RIVET	MSD040704-05-18	
1	6	646.3015	BLADE		
1	5	646.3014	BLADE		
1	4	646.3013	BLADE		
1	3	646.3012	LOWER GUIDE		
1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
11		601.2045	RTV, LOCTITE 598		
17	10	601.1868	LOCKNUT	MSD7543-04	
34	9	601.2764	WASHER	NASS14891-853P	
17	8	601.2765	SCREW	MSD7079-081R	
2	7	601.2766	RIVET	MSD040704-05-18	
1	6	646.3015	BLADE		
1	5	646.3014	BLADE		
1	4	646.3013	BLADE		
1	3	646.3012	LOWER GUIDE		
1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
11		601.2045	RTV, LOCTITE 598		
17	10	601.1868	LOCKNUT	MSD7543-04	
34	9	601.2764	WASHER	NASS14891-853P	
17	8	601.2765	SCREW	MSD7079-081R	
2	7	601.2766	RIVET	MSD040704-05-18	
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1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

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11		601.2045	RTV, LOCTITE 598		
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34	9	601.2764	WASHER	NASS14891-853P	
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34	9	601.2764	WASHER	NASS14891-853P	
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34	9	601.2764	WASHER	NASS14891-853P	
17	8	601.2765	SCREW	MSD7079-081R	
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1	2	646.3011	RH HALF		
1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

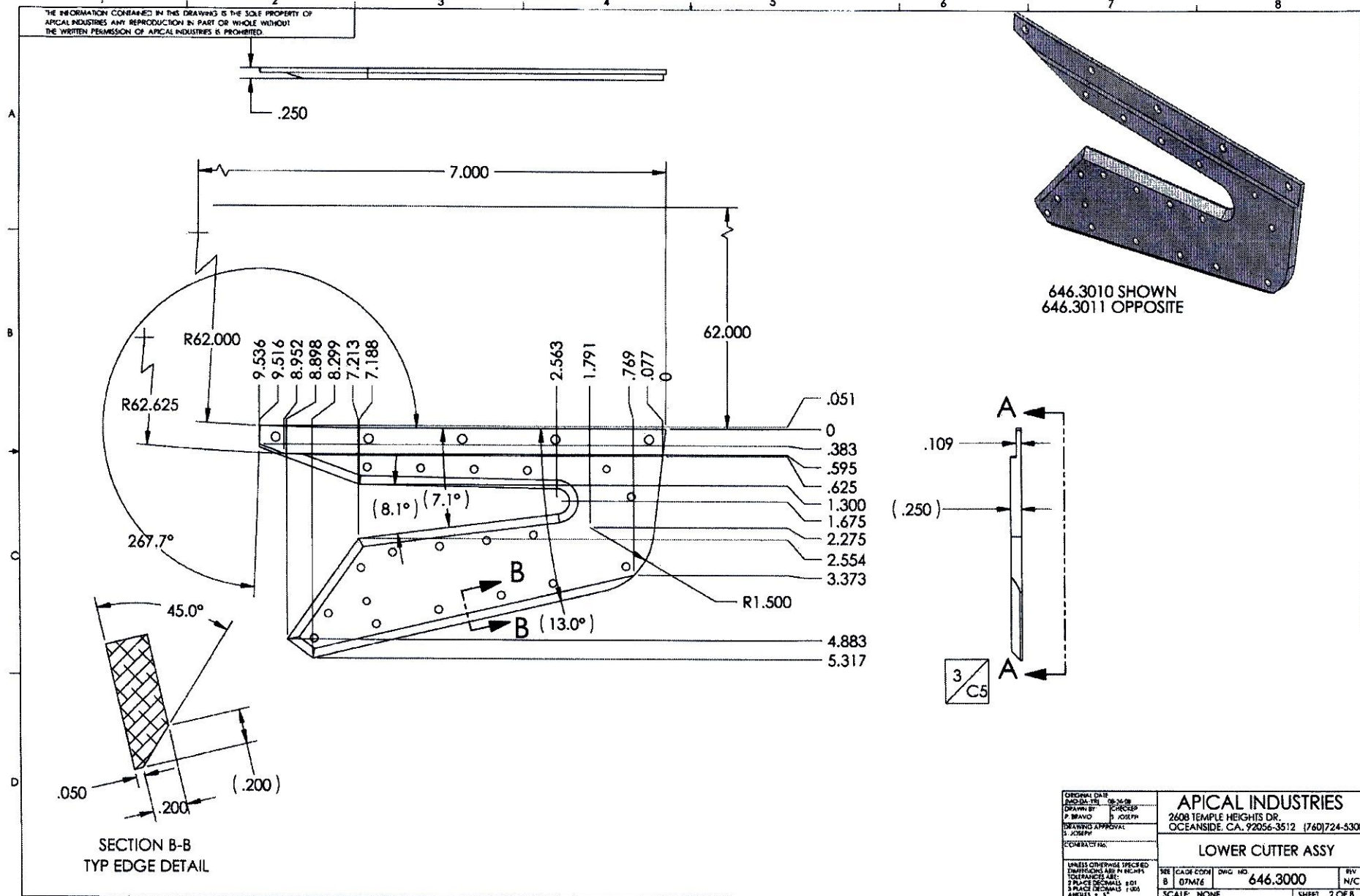
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11		601.2045	RTV, LOCTITE 598		
17	10	601.1868	LOCKNUT	MSD7543-04	
34	9	601.2764	WASHER	NASS14891-853P	
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1	1	646.3010	LH HALF		
1		646.3001	LOWER CUTTER ASSY		

QTY	FIND #	PART #	DESCRIPTION	MAT
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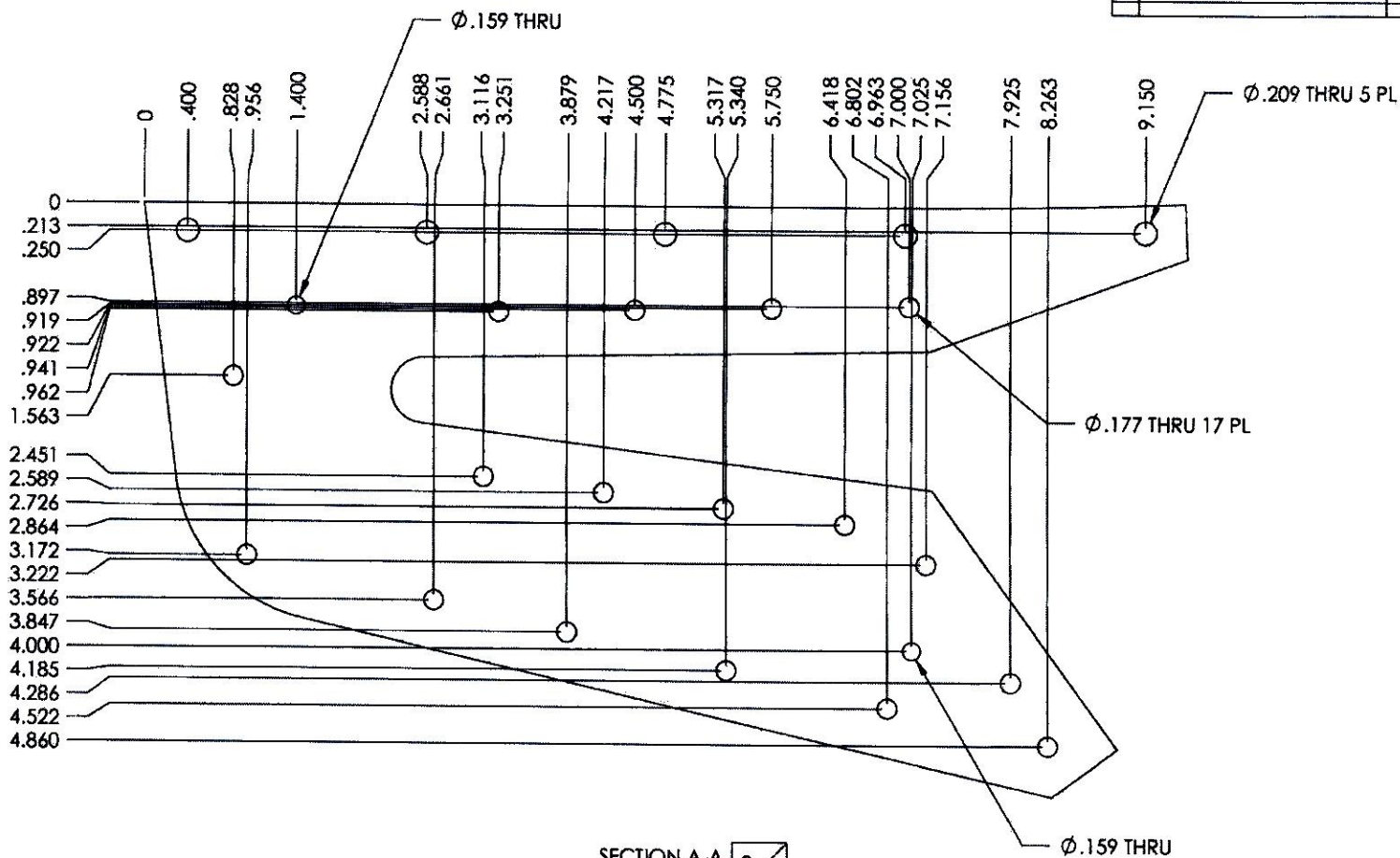
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ORIGINAL DATE 10-24-88		APICAL INDUSTRIES	
DESIGNED BY P. BRAYNO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH		LOWER CUTTER ASSY	
ECONOMIZATION		REV	N/C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .001 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SCALE: NONE	SHEET 2 OF 8

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

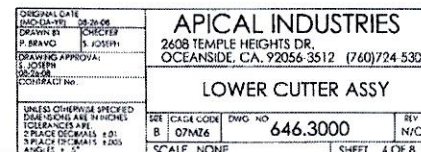
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



2
C7

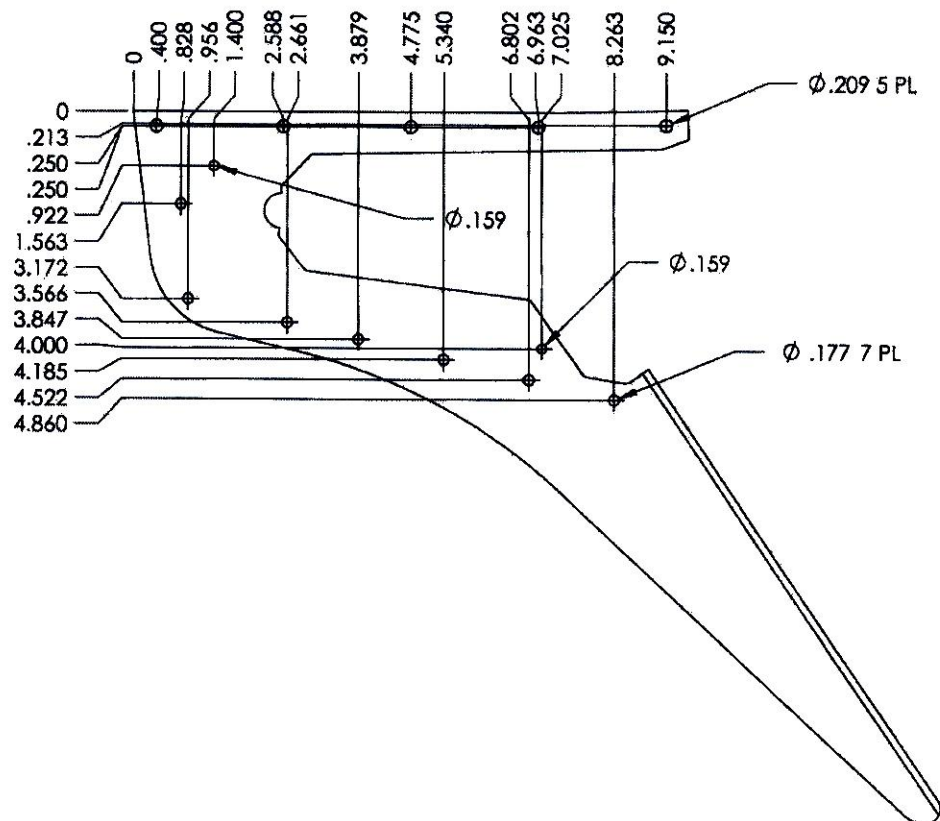
OPERATOR: J. JACKSON DATE: 08-29-00 DRAWN BY: P. BRAYO CHECKED BY: J. KIMPH DRAWING APPROVAL: J. KIMPH PROJECT NO.: CROSS-CUT: C76	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°	LOWER CUTTER ASSY REV: B CAGE CODE: 8 DWG NO: 646.3000 SCALE: NONE SHEET 3 OF 5

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



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REV.	DESCRIPTION	DATE	APPROVED

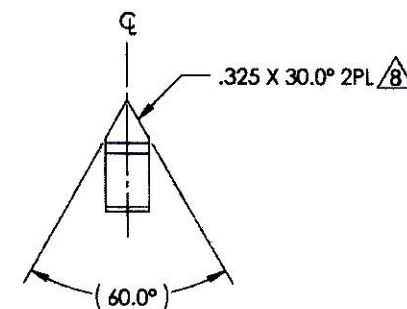
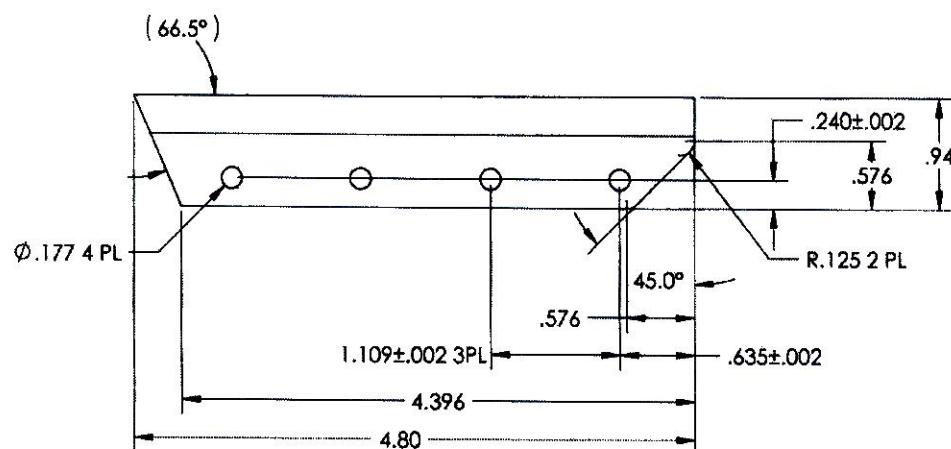
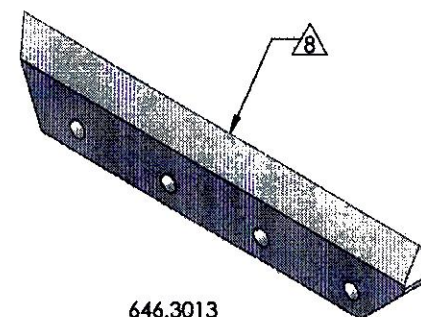


SECTION F-F 4
B6

ORIGINAL DATE 10/20/01 08:21:00		APICAL INDUSTRIES	
DRAWN BY P. BRAYO		2608 TEMPLE HEIGHTS DR.	
CHECKED BY S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		LOWER CUTTER ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .01 ANGLES 1/2°		REV. C A01 0000	DWG. NO. 646.3000
SCALE NONE		REV. B 07/02/02	REV. N/C
SHEET 5 OF 8			

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APICAL INDUSTRIES ANY REPRODUCTION IN PART OR WHOLE WITHOUT
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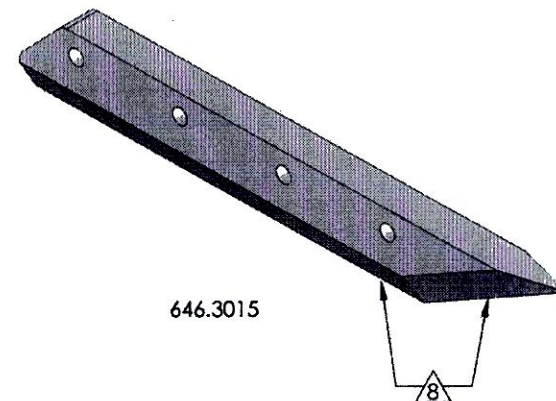
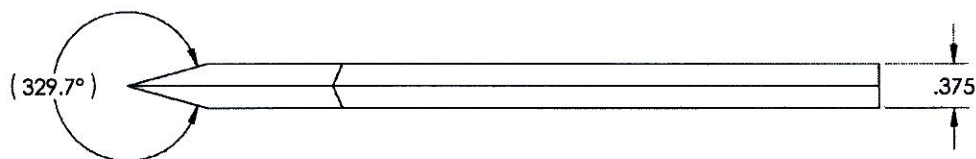
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



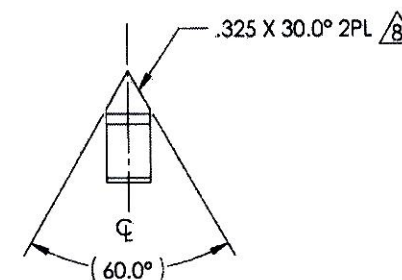
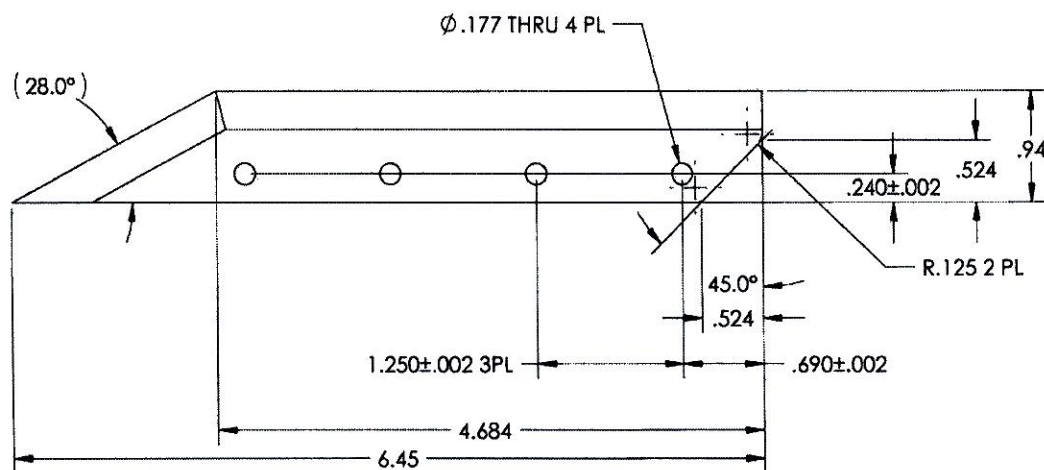
SPECIAL DATE (MAY-DA-10) 08-26-08 DRAWN BY (MAY-DA-10) J. COHEN CHECKED BY (MAY-DA-10) J. COHEN CONTRACT NO.	APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92066-3512 (760)724-5300 LOWER CUTTER ASSY
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS ANGLES .0005 .0001 .001	BRT. # 07426 DWT. NO. 646.3000 SCALE NONE SHEET 4 OF 8

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REV	DESCRIPTION	DATE	APPROVED



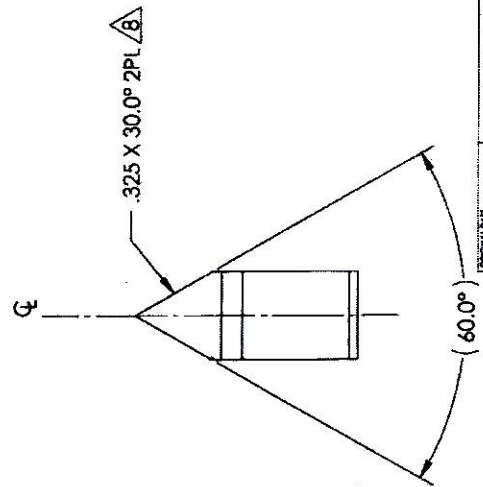
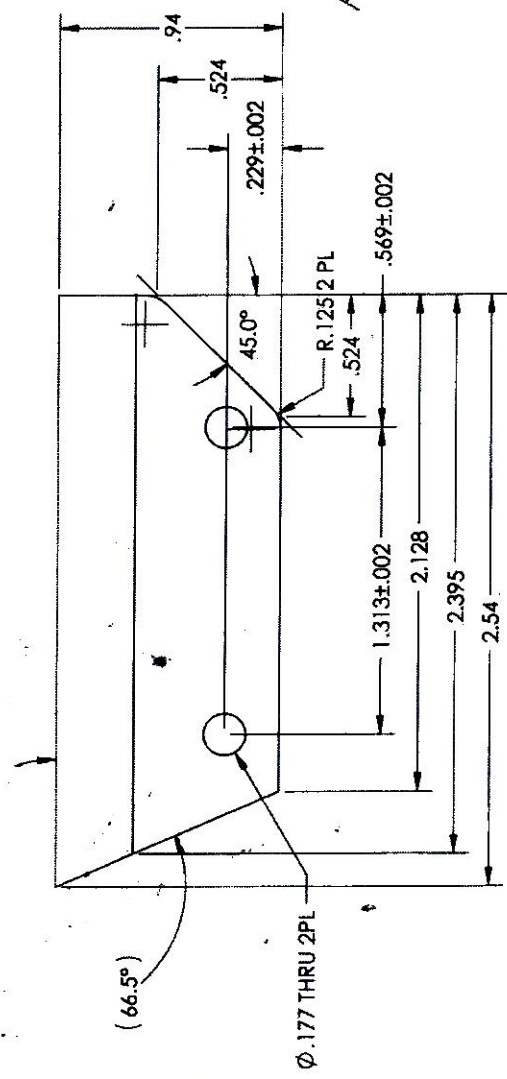
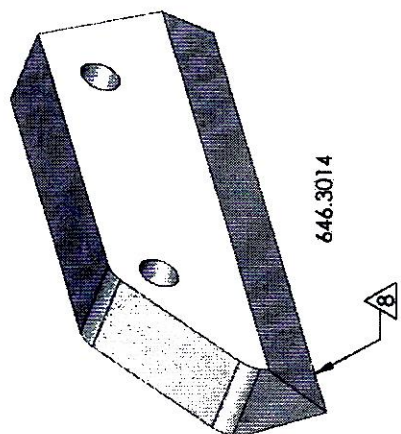
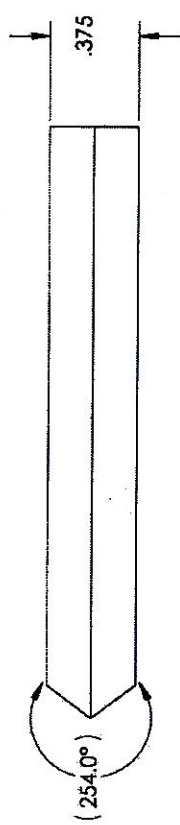
646.3015



ORIGINAL DATE 08-24-05	APICAL INDUSTRIES		
DRAWN BY P. MAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3312 (760)724-5300		
CHECKED BY S. JOSEPH	LOWER CUTTER ASSY		
APPROVED BY S. JOSEPH			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	REV 8	DATE CODE 07M26	DWG. NO. 646.3000
			REV N/C
		SCALE NONE	SHEET 8 OF 8

REV	DESCRIPTION	DATE	APPROVED

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APICAL INDUSTRIES		2408 TEMPLE HEIGHTS DR.		OCEANSIDE, CA. 92056-3512		(760) 724-5300	
LOWER CUTTER ASSY		DWG NO.		646.3000		REV	
SCALE		NONE		1 SHEET		7 OF 8	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO37428**

Purchase Order Date 8/15/2017

PO Print Date 8/21/2017

Page Number 2 of 3

Order From :

METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 450 473 1884

Ship To Contact

Ship To Phone

Ship Via: FedEx PI collect

Ship Acct:

3 164521 646.3014 Blade 8/21/2017
Yes
8/21/2017

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

DAS
9
9-89

Buyer

Diane Baker

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

10.00 \$6.54 \$65.43

SP A-8-29
DAS
38
9-89

Line Total: \$65.43

4 164368 646.3013 Blade 8/21/2017
Yes
8/21/2017

FINISH: HEAT TREAT TO 58-62 RC
ROCKWELL HARDNESS

PART ARE MADE FROM AISI A2 TOOL STEEL

Line Total: \$65.43

5 164078 D4202-1 Spacer 8/21/2017
Yes
8/21/2017

HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

303.00 \$1.00 \$301.61

Note:

8/21/2017

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
321169	1	121631

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
37428		A2	2017/8/17	MINIMAX

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

70 646.3014

(50) D5504-1 164784

DAS
9
9-89

(10) 646.3014 164521

(10) 646.3013 164368

1 VALISE

SEP 17-8-24

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
VALISE	1	

CERTIFICAT

EMPAQUETAGE Packing	
------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 70

POIDS EXPÉDIÉ / Weight Shipped : 15,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

APPROUVÉ

CERTIFICAT

QUANTITÉ EXPÉDIÉE Quantity Shipped: 70

POIDS EXPÉDIÉ / Weight Shipped : 15,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2017/08/23

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
321169	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
37428	N/A	A2		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

VAC HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	58 - 62 HRC	11	58 - 60 HRC

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
70	15	846.3014 (50) D5504-1 164784 (10) 846.3014 164521 ✓ (10) 846.3013 164368 1 VALISE

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

DATE: 2017-08-23

Pierre Piché
Chief Inspector



METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détail

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
321169	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
37428	N/A	A2		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
VAC HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results	
HARDNESS	58 - 62 HRC	11	58 - 60 HRC	
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
70	15	646.3014 (50) D5504-1 164784 (10) 646.3014 164521 (10) 646.3013 164368 1 VALISE		

COMMENTAIRES / comments

DOUBLE TEMPER 400F, 2 HRS

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification.

All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée.

Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

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